

SHIP FROM 17/07

Work Order ID 50556

July 15, 2009 11:11:40 AM

Page 1

Item ID: D3942-1

Accept

Revision ID: A

Item Name: Angle

Start Date: 7/15/09

Start Qty: 120.00

Required Date: 7/15/09

Req'd Qty: 120.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3942-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

=> ml 09.07.16

Ep 09/07/16

120

120

120

M. K 09/07/16

120x

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

=> ml 09.07.16

120

120

# Work Order ID 50556

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Page 2

Item ID: D3942-1

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Revision ID: A

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Start Date: 7/15/09

Start Qty: 120.00

Required Date: 7/15/09

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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

130

Memo

0.00

Brake NC

Brake NC

1- Bend as per dwg D3942

0.00

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

# Work Order ID 50556



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Item ID: D3942-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Angle

Start Date: 7/15/09

Start Qty: 120.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 120.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

9/7/17 200 SP

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/17  
MF 09-07-17

# Picklist Print

Page 1

July 15, 2009 11:11:39 AM

Work Order ID: 50556

Parent Item: D3942-1RevA

Parent Item Name: Angle



Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 120.00

Required Qty: 120.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S18GA 		Purchased	No			100	sf	186.8500	1.8947 			
304/316 .050 Sheet												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

186.85

108156

2.88

111743

23.97

112178

160

MW 09.07.16



556

☒ **First Article** ☐ **Prototype**

Measured by:	<i>M. M.</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	09.07.16	Date:	09/07/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.22	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

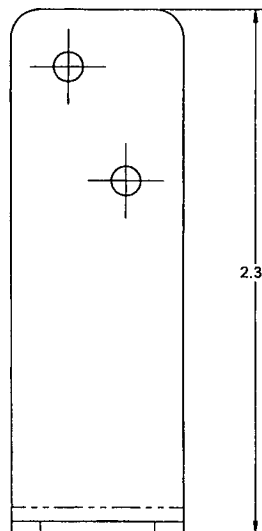
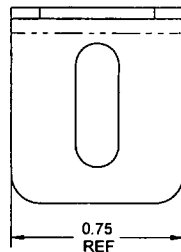
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

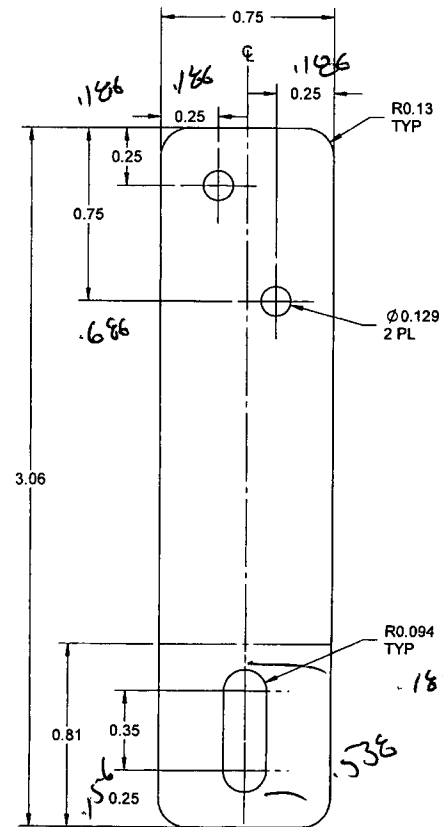
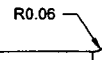
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. ~~50358~~ *50358*  
*MR 09-07-10*

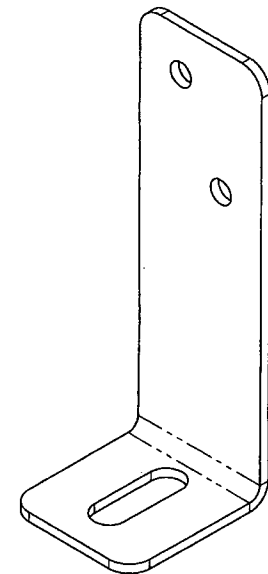


**D3942-1 ANGLE**  
MADE FROM D3942-1F

0.050  
REF



**D3942-1F FLAT PATTERN**



**RELEASED**  
*07/06/10*

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524  
18 GAUGE (0.050 THICK)  
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3942-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

A		NEW ISSUE		09.05.06	
REV.	DESCRIPTION	BY	DATE		
DESIGN				<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN					
CHECKED				DRAWING NO.	REV. A
MFG. APPR.				D3942	SHEET 1 OF 2
APPROVED				TITLE	SCALE
DE APPR.				BRACKET	NTS
DATE	09.05.06	<small>           COPYRIGHT © 2009 BY DART AEROSPACE LTD            THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS            NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT            WRITTEN PERMISSION FROM DART AEROSPACE LTD.         </small>			



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries